

Date: Tuesday, 1/3/2006 4:20:42 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG BRACKET	
Job Number	: 25383		Part Number	: D3046041	
Estimate Number	: 10364		Drawing Number	: D3046 REV. A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 1/3/2006 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 1/10/2006 Qty: 4 Um: Each	
Previous Run	: N/A				
Written By	: See comment below				
Checked & Approved By	: See comment below				
Comment	: Est: A 01.08.27 New issue SM/EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D30461	Lug Bracket		
				
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) <b>LUG BRACKET</b> Qty Part Number Description Batch 1 D3046-1 Lug Bracket B24715				
2.0	D30463	Lug Bracket		
				
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) <b>LUG BRACKET</b> <b>Pick:</b> Qty Part Number Description Batch 1 D3046-3 ( Bell P/N: 206-052-106-1) Lug Bracket N/A Return Authorization # 443 Bell original batch# 551749-24/550928-24 see w/o 25385				
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
				
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 1- Tranfer drill holes from D3046-3 into D3046-1 as per Dwg D3046 2- Counter sink inside holes of D3046-1 as per Dwg D3046 3- Deburr				
				
<b>Comment:</b> INSPECT WORK TO CURRENT STEP				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/3/2006 4:20:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 25383

Part Number: D3046041

Job Number:



Seq. #: Machine Or Operation:

Description :

3.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

SB 06/01/09

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



206-01-09

Comment: INSPECT POWDER COAT

7.0 MS20426AD57

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)

Rivet

Qty Part Number

Description

Batch

10 MS20426AD5-7

Rivet

M 3876

SB 06/01/09

4

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3046

SB 06/01/09

9

9.0 QC5

INSPECT WORK TO CURRENT STEP



206-01-09

4

Comment: INSPECT WORK TO CURRENT STEP

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

SB 06/01/10

4

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

206/01/10

(4) CL

12.0 PACKAGING 1

PACKAGING RESOURCE #1



~~206/01/10~~

(4)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

206/01/10

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/01/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/3/2006 4:20:43 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 25383

Part Number: D3046041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

06-01-10

Job Completion



06-01-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

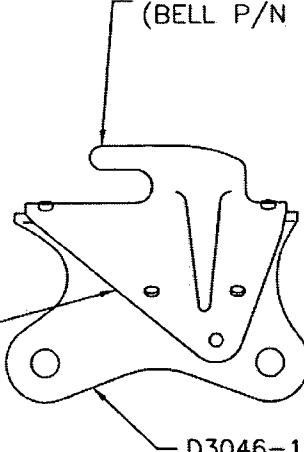
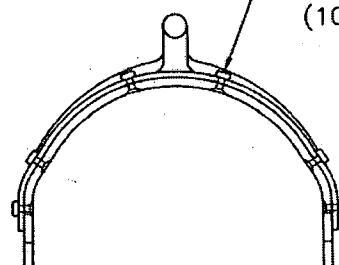
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**COPY ISSUED  
08-27

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3046	SHEET 1 OF 2
01.08.23	A	01.08.23	NEW ISSUE
			SCALE 1:2

D3046-3  
(BELL P/N 206-052-106-1)CENTER D3046-3  
ON D3046-1D3046-041 LUG BRACKET ASSEMBLY

CHIEF DESIGNER  
KETMAN  
ENG. ING.  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITH HOLD NOTICE

NOTES:

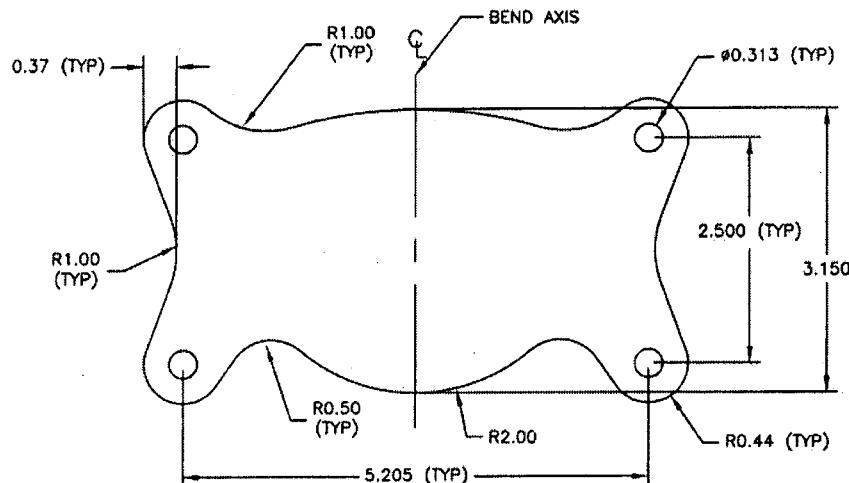
- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.  
RE-POWDER AFTER ASSEMBLY.
- 2) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

N.YORK 0000  
0000 25383**RELEASED**

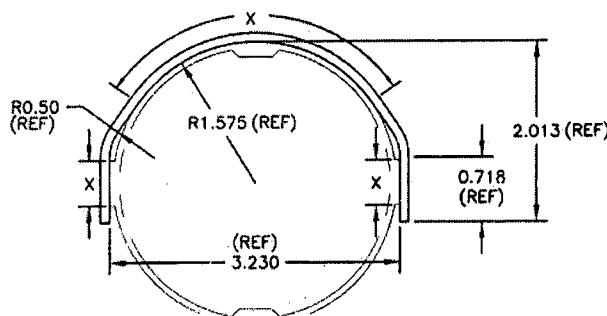
a.08-27

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	REV. A
DATE	01.08.23	DRAWING NO.	SHEET 2 OF 2
		TITLE	SCALE
		LUG BRACKET	1:2

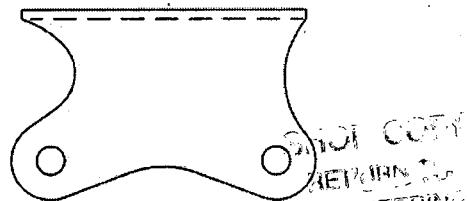


D3046-11 FLAT PATTERN  
SYMMETRICAL ABOUT CENTRE-LINES (C)



D3046-1  
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE  
OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.



WORK OF  
NO. 25383

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

RELEASED  
01.08.23

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## Linda Lacelle

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**From:** Holly Menard [hmenard@dartaero.com]  
**Sent:** Tuesday, January 03, 2006 10:42 AM  
**To:** 'Linda Lacelle'  
**Cc:** Peggy Macdonald; 'Heather Mahon'  
**Subject:** RE: DSI 9213

Spoke with Don Brooks the Lugs were shipped from his location. He can not confirm as to which courier was used or whether they were shipped on Thursday or Friday. However they are currently on their way to us.

Holly Menard  
Sales Associate  
DART Helicopter Services, LLC  
Tel: 1.613.632.3336  
1.800.556.4166  
Fax: 1.613.632.4443  
hmenard@dartaero.com  
www.darthelicopterservices.com <<http://www.darthelicopterservices.com>>  
"we're more than just skidtubes"

-----Original Message-----

From: Linda Lacelle [mailto:[llacelle@dartaero.com](mailto:llacelle@dartaero.com)]  
Sent: Tuesday, January 03, 2006 9:14 AM  
To: \*Peggy McDonald (E-mail); Heather Mahon (E-mail); Holly Menard (E-mail)  
Subject: DSI 9213

Do any of you know when we will be receiving the parts back from the customer to make these?

LL